

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003918**Date Inspected:** 17-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lin Yan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Skin Plate**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Orthotropic Box Girder (OBG) and Tower, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item	Description	WBS	Dwg No.	Status
1	Tower Skin Plate Tower	NA	NA	ZPMC Magnetic Particle

Heavy Duty Shop1: Caltrans QA inspector is present to witness ZPMC QC perform magnetic particle test (MT) per ZPMC notification of witness inspection, document number 01047. The subassembly is identified as segment 3, skin plate "E", NSD1-SA10J/K, weld; NSD1-SA10J/K 12 thru 15A/B, NSD1-SA10-K/K, weld; NSD1-SA10K/K, 5 thru 10 weld cover pass and segment 1, skin plate "E", NSD1-SA76G/H, weld; NSD1-SA76G/H 1 thru 6, NSD1-SA76F/H, weld; NSD1-SA76F/H 1 & 2 weld cover pass. The ZPMC MT coverage was observed to be one-hundred percent. The ZPMC QCMT inspector is identified as Mr. Su Wei. The ZPMC QCMT inspector, at the conclusion of the inspection, informed Caltrans QA inspector that the welds are accepted by QC and no relevant indications were observed.

Caltrans QA inspector performed ten percent MT inspection of segment 1 and 3, skin plate "E", welds. The welds appeared to be in conformance with the project specifications. See Caltrans Magnetic Particle Test Report (TL-6028) dated September 17, 2008 for additional information.

**Summary of Conversations:**

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## WELDING INSPECTION REPORT

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As identified within the contents of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Josha Isibashi, 137-6471-0411, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler,Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar,Robert	QA Reviewer

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